

Date: Monday, 08/09/2008 2:50:45 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |   |                           |             |
|------------------------------------|---|---------------------------|-------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services         | <b>Drawing Name</b> :     | TUBE        |
| <b>Job Number</b> :                | 41889                                       |                           |             |
| <b>Estimate Number</b> :           | 11168                                       |                           |             |
| <b>P.O. Number</b> :               |   | <b>Part Number</b> :      | D22823      |
| <b>This Issue</b> :                | 08/09/2008                                  | <b>S.O. No.</b> :         |             |
| <b>Prsht Rev.</b> :                | NC  | <b>Drawing Number</b> :   | D2282 REV E |
| <b>First Issue</b> :               | / /   | <b>Project Number</b> :   | N/A         |
| <b>Previous Run</b> :              | 38640                                       | <b>Drawing Revision</b> : | E           |
|                                    | <b>Type</b> :                               | <b>Material</b> :         |             |
|                                    | MACHINED PARTS                              | <b>Due Date</b> :         | 30/10/2008  |
| <b>Written By</b> :                |   | <b>Qty:</b>               | 100         |
| <b>Checked &amp; Approved By</b> : | JLD 08.9.08                                 | <b>Um:</b>                | Each        |
| <b>Comment</b> :                   | Est Rev:A Removed from 9 Digit 05-12-02 JLM |                           |             |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TR0675W091 | 304 RD Tube .675 x .091W |
|-----|----------------|--------------------------|



**Comment:** Qty.: 0.2078 f(s)/Unit Total : 20.7795 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch M109364

mm = 08/09/28

100

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

mm = 08/09/28

100

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mm = 08/09/28

100

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

mm = 08/09/28

100

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

STDS 08/09/28 (100)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 08/09/2008 2:50:45 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 41889

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JMF 08-09-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

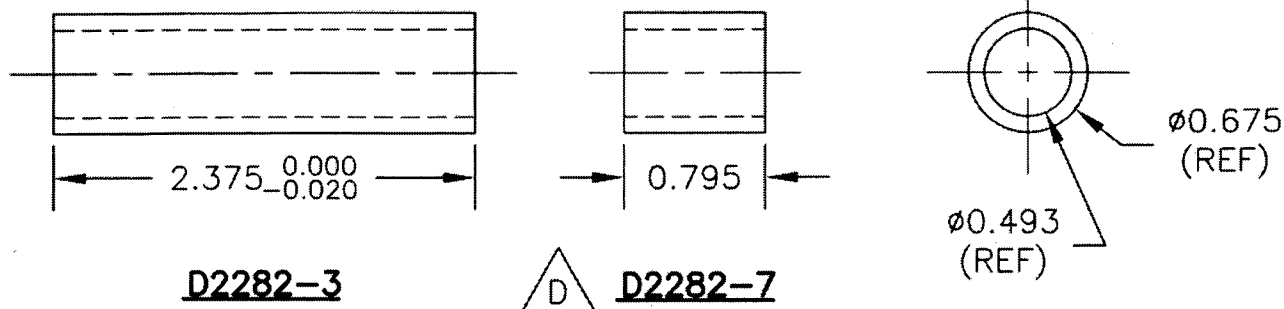




|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |
| A                             | 94.10.14                       | NEW ISSUE   |                        |
| B                             | 95.03.23                       | RE-DESIGN   |                        |
| C                             | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                             | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                             | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

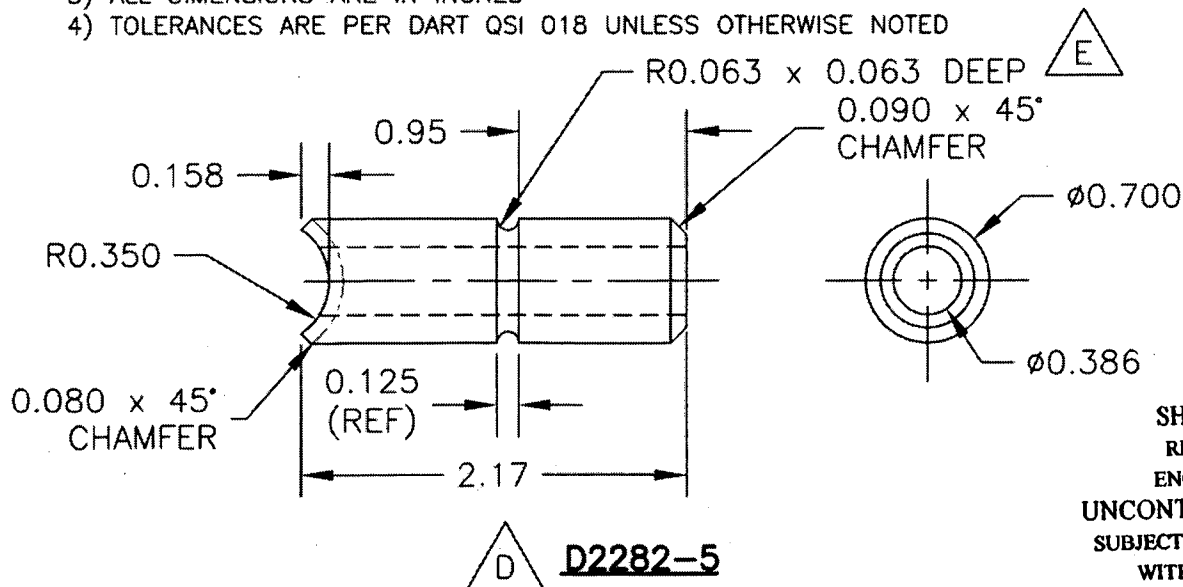
RELEASED  
*[Signature]*

05/09/16



**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

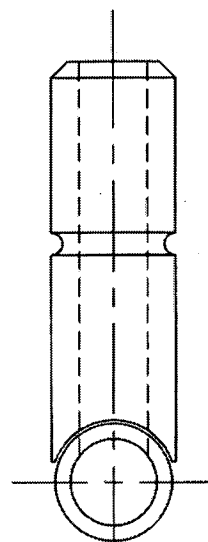
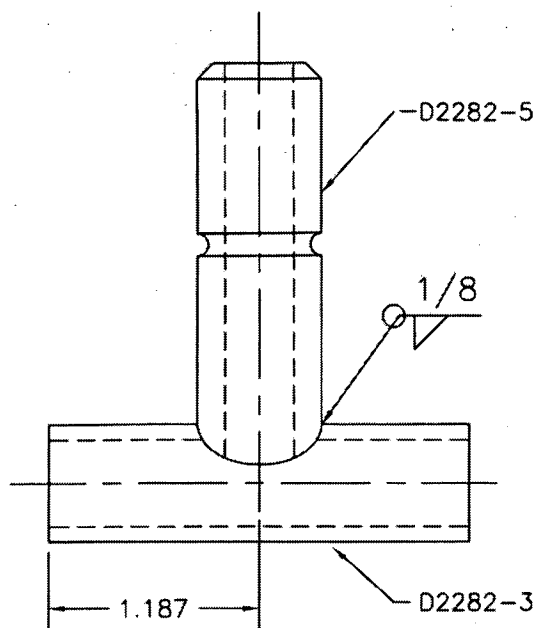
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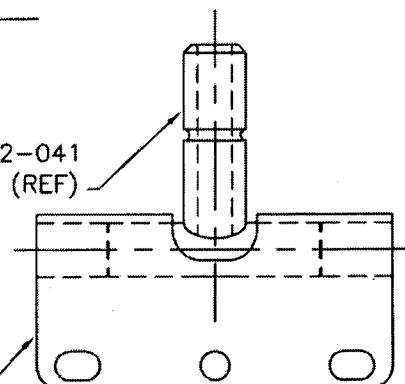
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|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
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| CHECKED<br><i>UP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07     | TITLE<br>HANDLE TUBES          |   | SCALE<br>1:1           |

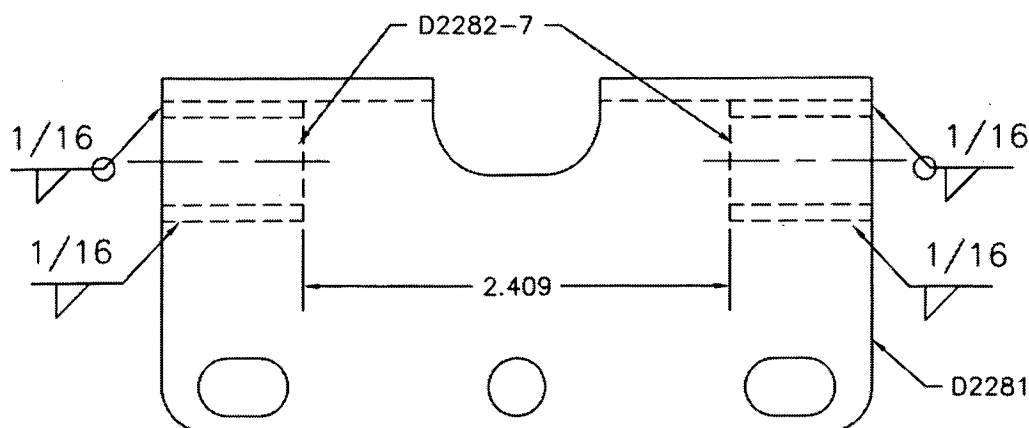


D2282-041  
(REF)



D2282-043  
(REF)

**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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